

Work Order ID 132535

132535

May-07-15 2:52:05 PM

Page 1

Item ID: D4776-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube Clevis
 Start Date: 5/07/15 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4776	D

100	BAND SAW	0.00							
100									
Bandsaw	Memo 113	0.00							
Jeaspa Bandsaw	Cut Blank at 4.400"								

110	HAAS CNC VERTICAL MACHINING #1	0.00							DAS
110									40
HAAS 1	Memo	0.00							9-89
HAAS CNC vertical machine #1	1-Machine per folio FB168								
	DWG REV: 0								
	FOLIO REV: 00								

2- deburr and break all sharp edges

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 132535

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Page 2

Item ID: D4776-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube Clevis

Stop ***NS2***

Start Date: 5/07/15 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

15-05-15

20

130 QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS

44

9-89

15/09/20

20

0

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

20

0

15/06/01

DQA: _____ Date: _____



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Picklist Print

May-07-15 2:52:05 PM

Page 1

Work Order ID: 132535

132535

Parent Item: D4776-3

D4776-3

Parent Item Name: Skidtube Clevis

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM
REV:B 13.09.26 AS PER REV.B DD VERF:JLM
PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM
IPP
IPP REV:C AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No			100	f	19.3200	0.367	7.726316			

M6061T6B1 500X02 500

6061-T6 Bar 1.50 x 2.50

Location

MAT004

Loc Qty

19.32

Loc Code

m128980

7.32

m129666

12

Not in

System

M128054

15-05-15

3.4

4.2'

DQA: _____ Date: _____



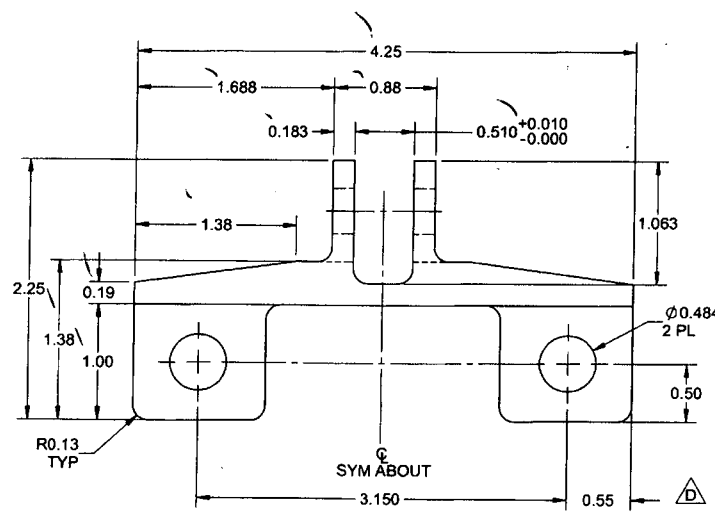
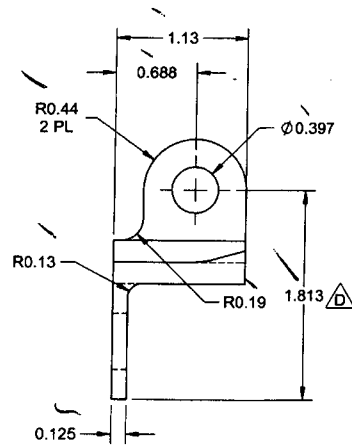
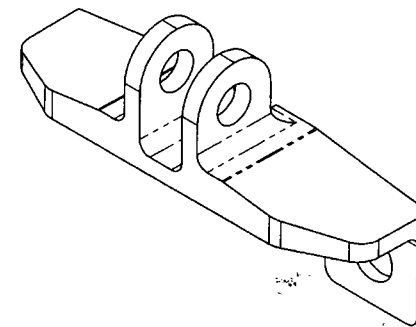
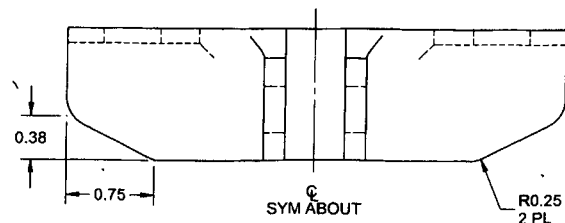
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OTHER: _____																																																																				

132535



GRAIN
DIRECTION

RELEASED
2014-07-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.18 lbs

D4776-3 SKIDTUBE CLEVIS

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4776	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT MACHINED PARTS	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	